Work Order ID 61626

Monday, August 30, 2010 2:38:49 PM

Item ID: D2562-001 **Accept** **Setup Start** **Stop**

Revision ID:

Item Name: Strut

Start Date: 8/30/2010 **Start Qty:** 8.00 **Cust Item ID:**

Required Date: 9/6/2010 **Req'd Qty:** 8.00 **Customer:**

Reference:

Approvals: **Process Plan:** N/ **Date:** 10-8-30 **Tooling:** _____ **Date:** _____ **Run Start** **Stop**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr: D2562 / Revision Nbr: Rev D						8X			
100	NC BRAKE	0.00							
Brake NC									
Brake NC	**Memo** Punch to length as per Dwg D2562	0.00							
110	Small Fab	0.00							
Small Fab						x8			
Small Fab	**Memo** 1- Bend end as per Dwg D2562 Angle "D" 2-Deburr	0.00							
120	QC5- Inspect part completeness to step on W/O	0.00							
QC						x8			
Quality Control	**Memo**	0.00							

M-L 10/10/06

M-L 10/10/06

10/10/06

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2562-001 PAR #: _____ Fault Category: _____ NCR: Yes (No) DQA: 1 Date: 10-10-06

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR: 61626		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B: Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector
10.10.06	100	Q48 struts are 19.740" long from hole to hole instead of 19.68" ± 0.030". Parts are only roughly 0.030" over tolerance.	QP 10.10.06 QS1042	Acceptable in QA opinion Acceptable.	M-L 10/11/06	S 10/10/07	QP 10.10.06 QS1042	1 10.10.06

NOTE: Date & initial all entries

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Revision ID:

Item Name: Strut

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Reference:

Run Start **Stop**

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel	0.00	BK 10-10-8						
Powdercoat	M115291					8			
Powder Coating	**Memo**	0.00							
	START TIME: 8:40 ☐OVEN TEMPERATURE: 400° ☐FINISH TIME: 9:10								
140	QC3- Inspect Part Finish	0.00	=> M 10/10/12			8	9		
QC	**Memo**	0.00							
Quality Control									
150	Identify as per dwg & Stock Location: ~~212~~ 264	0.00							
Packaging	**Memo**	0.00				10/10/12 (8)			
Packaging									

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Work Order ID 61626

Monday, August 30, 2010 2:38:49 PM

Item ID: D2562-001
Revision ID:
Item Name: Strut
Start Date: 8/30/2010 **Start Qty:** 8.00
Required Date: 9/6/2010 **Req'd Qty:** 8.00
Reference:

Accept

Setup Start
Stop

Cust Item ID:
Customer:

Run Start
Stop

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC21- Final Inspection - Work Order Release	0.00					10/10/12		
QC Quality Control	**Memo**	0.00							

MF
10-10-12

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Picklist Print

Monday, August 30, 2010 2:38:54 PM

Work Order ID: 61626

Parent Item: D2562-001

Parent Item Name: Strut

Start Date: 8/30/2010 **Required Date:** 9/6/2010

Start Qty: 8.00 **Required Qty:** 8.00

Comments: IPP □F□02.04.15□Added dwg Rev.B1□ NG□

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304TR0.500W.035		Purchased	No			100	f	182.2927	1.7067	14.37221			
304 RD Tube .500 x .035W													

Location	Loc Qty	Loc Code
MAT	182.292727	
114482	6.299977	
115180	15.99275	
115535	160	
MAT014	0.00002	
114356	0.00002	

M115535

m-l 10/08/31

14-37221

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

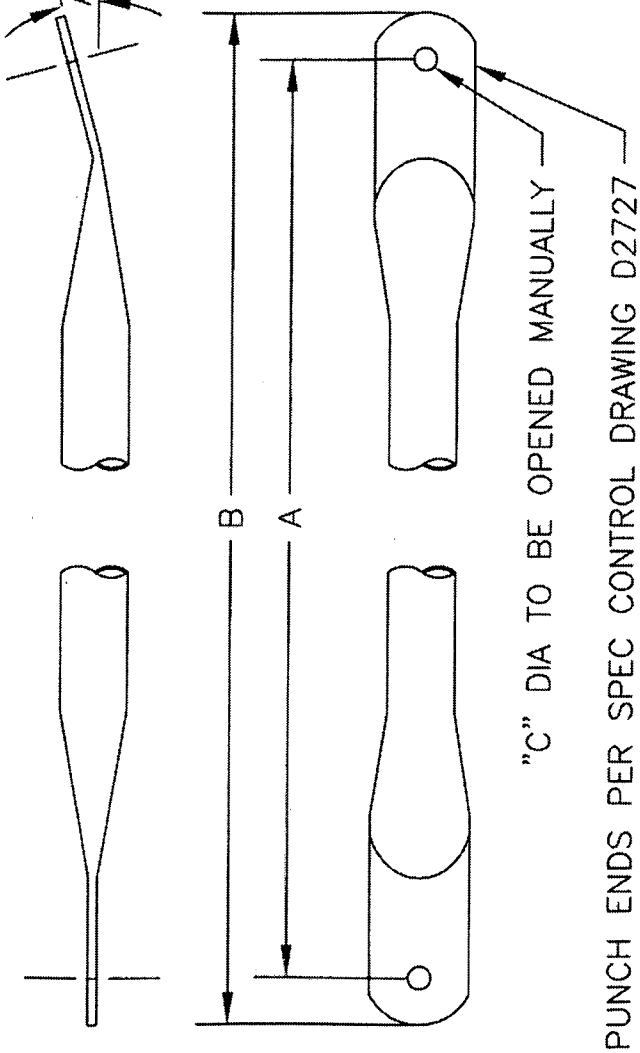
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

DESIGN	DRAWN BY	DART AEROSPACE LTD
CP	RF	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. REV. D
		D2562 SHEET 1 OF 1
DATE		TITLE SCALE
05.05.18		STRUT 1:2

A	96.05.01	NEW ISSUE
B	98.10.15	UPDATED MATERIAL NOTE (TSR A603)
C	02.06.05	ADD −005; ADD FINISH
D	05.05.18	ADD −007/−011/−013; UPDATE −005

RETURN TO ENGINEERING
UNCONTROLLED COPY
SUBJECT TO ... WITHOUT NOTICE
WORK ORDER NO. 61424
BPIO 8-30



PART #	DIM A	DIM B	DIA C	ANG D
D2562−001	19.68	20.48	—	10
D2562−003	20.37	21.17	—	18
D2562−005	29.00	29.80	—	30
D2562−007	19.22	20.02	—	0
D2562−011	25.79	26.59	—	16
D2562−013	26.63	27.43	—	24

GENERAL NOTES
1) MATERIAL: AISI 304/316/318 SS 0.500 OD X 0.035 WALL (REF DART SPEC. M304TR0.500W.035)
ENSURE SEAMLESS TUBE IS USED
2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
3) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES

RELEASED
05-05-27

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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

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NOTE: Date & initial all entries